Work Ordo Monday, June 2				*103386*								Page 1
Item ID: Revision ID: Item Name:	D3914-041	Lid Assembly (350	))	Accept	*N900	040	100	<b>N</b> *	Setup S	tart Stop	*N	S1*
	6/24/2013	Start Qty: 1 Req'd Qty: 1	.00 *1		Cust Item :	ID:				•	"N	S)"
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):		ate:		]		tart Stop	*N *N	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		leject lumber	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
D3914	С											
D4020	Α		:									
*100 *100* Large Fab Large Fab		Large Fab  Mem 1 - ass 2 - we ***V 3 - tac ***C D402	semble ribs, weld as per deld hinge (3) and Mounting isual inspect before weldings weld mesh on basket as ut out mesh where label pl	0.00 lwg D3914 using DT9607A g brackets as per dwg D3914 ng mesh***		3-7-1	<i>(</i>	1x				
*11 <b>0</b> *11 <b>0</b> * oc		QC9- Inspect visu	ual per QS1004- Fusion We	0.00 0.00					13-1	0]-1	5	DACON 09

Quality Control

\*103386\*

Page 2

Monday Ivas 24 2012 11:26:46 AM

Monday, June 2	4, 2013 11:2	0:40 AM								
Item ID: Revision ID:	D3914-041			Accept	*N900	040	100	<b>)*</b> s	etup Star	ו בימו
Item Name:	Long Basket I	Lid Assembly (350)							Stop	*NS2*
Start Date:	6/24/2013	Start Qty: 1.00	*1*		Cust Item	ID:				
Required Date:	: 7/5/2013	<b>Req'd Qty:</b> 1.00	*1*		<b>Customer:</b>					
Reference:			-							
Approvals:	Process Pla	ın:	Date:	Tooling:	D	ate:	_	R	lun Star	"NR1"
	QC:		Date:	_ SPC (Y/N):	D	ate:			Stop	*NR2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
120		QC5- Inspect part compl	leteness to step on W/O	0.00						PAGE
*120*									13-07	15 (2)
QC		Memo		0.00						
Qualitý Control										
130		Black Sandtex(Ref:4.3.5	5.7) per OSI005 4.3	0.00					,	
*130*								/	d	A 13-7-K
Powdercoat		Memo	345	0.00					7-1	10 1/00
Powder Coating		*** mask si Start Time: Oven Temp Finish Time	erature:	lercoat***						
140		Wing Walk as per dwg (	QSI005 4.4 Batch / 1) 7	16091					,	
*1 <b>4</b> 0*								1x	_d_	11/07/1
HandFinish		Memo		0.00					-, -	
Hand Finishing		I - Mask da	ta plate and apply wing wa	alk on outside surface of m	nesh as per dwg					
		2- Install nle	acard and label as ner dwo	•						

2- Install placard and label as per dwg
\*\*\*Mask label plate to size of label, use scotchbrite red pad to lightly sand area
for label, apply label \*\*\*

Work Orde Monday, June 2					Page 3					
Item ID: Revision ID: Item Name:	D3914-041	Liú Assembly (350)		Accept	*N90004	<b>4</b> 0100	)*	Setup Sta	1\	IS1* IS2*
Start Date: Required Date: Reference:	6/24/2013	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:				IX	1.7/
Approvals:		nn:	Date:	Tooling: SPC (Y/N):					art *N	IR1* IR2*
Sequence ID/ Work Center II 150 *150* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID To	ool # Plan Code	Accept Qty	t Reject Qty	Reject Number	Insp. Stamp
*160 *160* Packaging Packaging		Identify as per dwg & St	ock Location: WO	0.00 D403 0.00	6-041 (B100)	363	_\x		<u></u> el	13/04/23
170 *170* QC Ouality Control		QC21- Final Inspection -	Work Order Release	0.00				13/	1/29	H

MF 13-7.25

## **Picklist Print**

Monday, June 24, 2013 11:26:50 AM

Work Order ID: 103386

\*103386\*

Parent Item:

D3914-041

\*D3914-041\*

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/24/2013

Required Date: 7/5/2013

Page 1

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

IPP Rev:A new issue DD 10.03.19 verified by:EC

IPP Rev:B

as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:C 13.03.14 AS

PER DWG REV.pc1 DD VERF:JLM IPP REV:D 13.06.21 DWG

REV.C DD VERF:JFS

K	EV.C DD VER	L'1L2											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3914-1		Manufactured	No			100	Each	12.0000	2	2			
*D3914-1*	•								**	B 103	3365-	-> -> -> ->	
Kib				Location		Loc	<u>Oty</u>	Loc Code			L	Y13.	97.11
				WA004			8				_	1/	/ 
					100751		6				_	1	
					88645		2		_		_ (		
				WA005			4		_	-	_	/ \	
					81449		1				_	/	
					82131		1				_	I	
					87079 97660		1		_				
D3914-7		Manufactured	No		77000	100	Each	13.0000	2	2	_		
*D3914-7*	•								** =	B100	888 -	<del>&gt;</del> 2x	
Rib				<u>Location</u>	<u>.</u>	Loc	<u>Oty</u>	Loc Code			Sy	13.	DA·//
				WA004			8				_		
					100888		8						
				WA005			5				_		
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Monday, June 24, 2013 11:26:50 AM

\*103386\* Work Order ID: 103386 Parent Item: D3914-041 \*D3914-041\* Parent Item Name: Long Basket Lid Assembly (350) Start Date: 6/24/2013 Required Date: 7/5/2013 Start Oty: 1.00 Required Otv: 1.00 D4018-5 100 Manufactured No Each 36 0000 \*\* \*D4018-5\* B 100347 > 9x Rib SY13.07.11 Loc Code Location Loc Otv WA004 36 100348 36 100 14.0000 D4035-043 Each Manufactured No \*D4035-043\* Lid Rib Assembly, Aft (350 Basket) Location Loc Qty Loc Code WA004 97078 97686 97687 WA005 81202 81452 82988 98841 26.0000 D2581 Manufactured No 100 Each B 103100 - 201 M13.07.11 \*\* Mounting Bracket Location Loc Qty Loc Code WA004 26 101383 12 70766 2 81253 82506 2 83230 3 2 85452 2 87706 99837 2

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Monday, June 24, 2013 11:26:50 AM

Parent Item:

Work Order ID: 103386

D3914-041

\*103386\*

\*D3914-041\*

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/24/2013

Required Date: 7/5/2013

Start Oty: 1.00

\*\*

\*\*

Required Oty: 1.00

\*D2728-3\*

Dart Logo label large

D4016-3

D2728-3

Manufactured No

Manufactured

100

140

Each

Each

Each

38 0000

0.0000

B101043-3x

\*D4016-3\*

Hinge Half, Lid

Location	Loc Qty	Loc Code
WA004	38	
101043	20	
102214	8	
0.4888		

100

94755 95563 SJ 13.04.11

D4020-5

Manufactured

No

No

4.0000 \*\*

B98400 SU13.67.11

\*D4020-5\*

Mesh (350 Basket Long, Lid)

Location	Loc Q	<u>Oty</u>	Loc Code
WA007		4	
92695		3	
96611		1	
	100	Fach	62 0000

Manufactured No

\*\*

B101346 SY 13.07.11

\*D4021-3\*

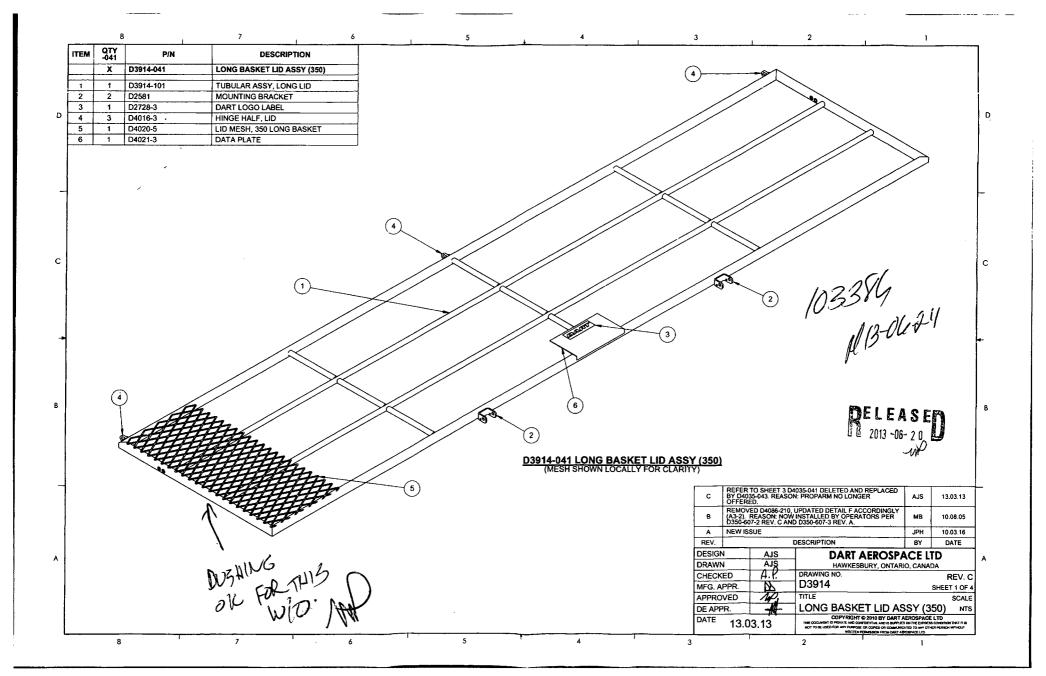
Data Plate

D4021-3

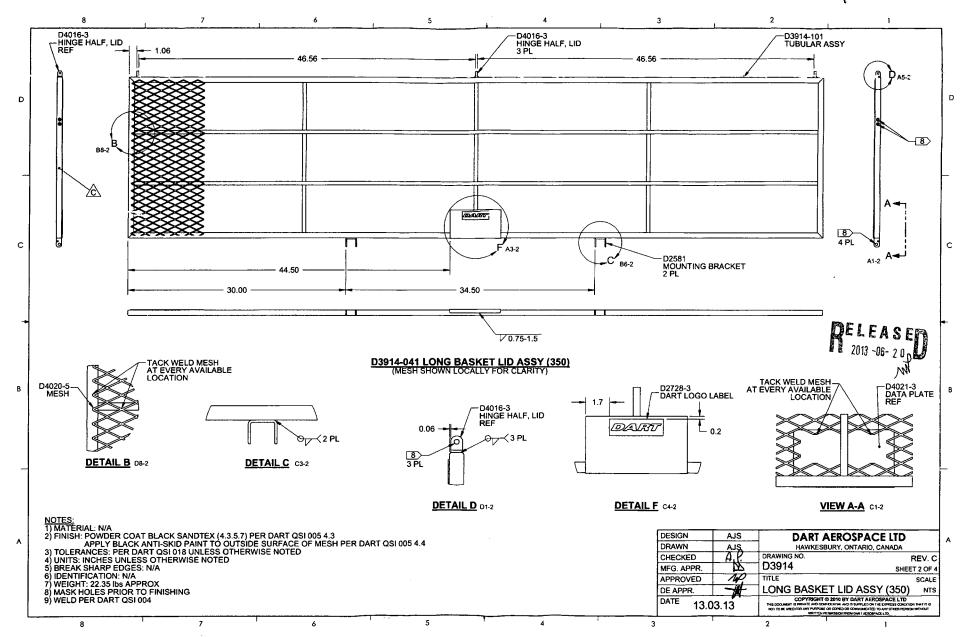
Location	Loc Qty	Loc Code
WA004	62	
101346	52	
80897	9	

14035-041 (gly) Betch : B103905

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NCR: Ye	s / No				WORK ORDER NON-	COI	NFORM	MANCE / UPE	DATE	DQA:		, ,
Work Order	<u>.</u>				DISPOSITION				AGAINST	DEPARTMENT	PROCESS	
Part No	)				Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Ooc/Data												
quip/Tooling												
Operator						1						
Material			1									
etup												
Other												
rocess						İ						
Supplier												
Training		1										
Jnapproved		<b>[</b>										
						FAUL	T CATE	GORY				
Landing	g Gear				General		_				-	_
	Bending				Bend	L	Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to C	o/s	BOM/Route		Hardwa	are		Over/Unde	r tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ect	Weld
	Crushed/	Crimped			Burrs		Instruct	tions Incomplete/L	Inclear	Part Lost/N	lissing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved	·	
	Heat Trea	at			Countersink		Mislabe	eled		Positioned '	Wrong	_
	Inspectio	n Strip in	Tube		Cut Too Short		Misrea	d		Power Loss	/Surge	Other
	Ripples in	n Bend			Drill Holes		Offset					
T T	Torque V		Extrusior	, [	Drawing	,	Out of	Calibration				
	Turning S	Sequence	<b>:</b>		Finish		Out of	Sequence				
	Wave/Tv	vist in Tu	be		Folio		Outside	e Dimensions				

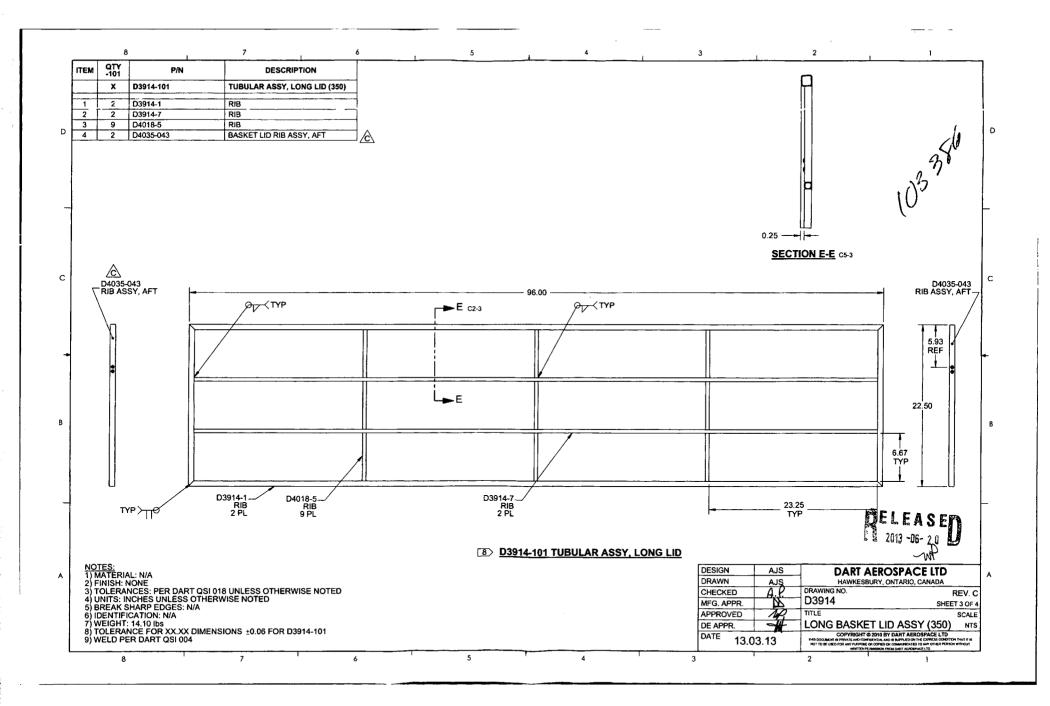


NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE						
		QA Closed:					
Wards Ondaris	DISPOSITION	AGAINST DEPARTMENT/PRO					
Work Order:							

										QA Closed:	Da	te:	
Work Order	<b>;.</b>				DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Prod. Eng. Coor.  Rec/Store/Packaging			ering ality other
Root				Descri	ption of work order update	ln	itial	Ac	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verificatio	n QC In	spector
Doc/Data													
Equip/Tooling						1							
Operator													
Material													
Setup													
Other						1							
Process													
Supplier													
Training						1							
Unapproved													
					F.	AUL1	CATE	GORY				<del></del>	
Landin	g Gear			_	General	_			_	_		<del></del> 1	
	Bending				Bend	$\square$	Grain			Ovalized		Pressure/	
	Centre N	ot Conce	ntric to	o/s	BOM/Route	-	Hardwa	lware		Over/Under	tolerance	Temperat	ure/Cure
	Cracks	Cracks			Broken/Damaged	-		ion Incomplete		Part Incorre		Weld	
	Crushed/Crimped				Burrs	-		nstructions Incomplete/Unclear		Part Lost/M	_	Wrong Sto	ock Pulled
	Cuffs				Contamination	$\vdash$		enance	_	Part Moved			
	Heat Treat				Countersink	Н	Mislabe			Positioned \			
	Inspection Strip in Tube			Cut Too Short	$\vdash$	Misrea	d	L	Power Loss/	'Surge	Other		
]	Ripples it				Drill Holes	$\vdash$	Offset						
	Torque V			n L	Drawing			Calibration					
	Turning S	•			Finish	${oldsymbol{dash}}$		Sequence					
	Wave/Tv	Wave/Twist in Tube Folio					Outside	Dimensions					

DQA:

Date:



NCR:	Yes	1	No
NUN.	162	1	140

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_Date: \_\_\_\_\_

NCR: YE	2S / NO	)			AAOKK OKDEK IAOIA-	-COIA	runi	MANUE / UPL		QA Closed:	Date	e:		
Work Orde	<del>.</del> .				DISPOSITION	T	AGAINST DEPARTMENT/PROCESS							
Work Order	•			· · · · <u>-</u> · · · · · · · · · · · · · · · · · · ·	Rework	¬		Skid-tube	Crosstube		Water Jet	Engineering		
Part No	0				Scrap	- 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
raitiv	·				Use-as-is	-		noforming	Finishing		e/Packaging	Other		
NCR N	0				Work Order Update	┥ [		Large Fab	Composite	1100,500	Supplier	<b>-</b>		
richt iv	·- <u></u>				Work order opaute	-								
Root				Descr	ription of work order update	ln	itial	Act	ion	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Descr	ription	Date	Verification	QC Inspector		
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upplier	7		ł											
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•						FAULT	CATE	GORY						
Landin	g Gear				General				· • • · · ·		_			
	Bendir	ng			Bend		Grain			Ovalized		Pressure/Forced		
Ī	Centre	Not Conc	entric to	o/s	BOM/Route	⊢ ∏,	Hardware			Over/Under tolerance		Temperature/Cure		
ļ	Cracks	Cracks Broken/Damaged					Inspection Incomplete			Part Incorrect		Weld		
Ī	Crushe	Crushed/Crimped Burrs					Instructions Incomplete/Unclear			Part Lost/Missing Wrong Stock Pu		Wrong Stock Pulled		
Ī	Cuffs	<b>→</b>					Mainte	nance		Part Moved				
}	Heat Treat Countersink					Mislabe	eled		Positioned V	Vrong				
		tion Strip i	n Tube	<u> </u>	Cut Too Short		Misread	<del>1</del>		Power Loss/	Surge	Other		
t	_	s in Bend			Drill Holes	Щ	Offset							
ţ	_ ``	e Waves in	Extrusio	n h	Drawing	-	Out of Calibration							
Ì		g Sequenc		<u> </u>	Finish	$\Box$	Out of S	Sequence				· · · · · · · · · · · · · · · · · · ·		
	Wave/Twist in Tube Folio						Outside Dimensions							

15.13 15.61 - 19.52 -R3.0 TYP (SEE D4020-1 FOR LENGTH) 9 D4020-3 (350 BASKET SHORT, BASE) (SEE D4020-3F FOR LENGTH)

NOTES:
1) MATERIAL-1: MAKE FROM D4020-1F
-3: MAKE FROM D4020-3F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: SEE D4020-1F & D4020-3F
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY

DELEASE 1 2010 -03- 1 2

					: 1						
Α	NEW IS	SUE		JPH	10.03.04						
REV.			DESCRIPTION	BY	DATE						
DESIG	N	AJS	DART AEROSPACE LTD								
DRAW	N	JPH	HAWKESBURY, C	-							
CHECKED (7)			DRAWING NO.	REV. A							
MFG. APPR. E			D4020		SHEET 1 OF 4						
APPRO	VED	JW	TITLE		SCALE						
DE API	PR.	-#	350 BASKET ME	SH (BASE	) NTS						
DATE	10.0	3.04	THE SOCIALIST OF STREET PROPERTY OF STREET S								

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											DQA:	Date:	
NCR: Ye	es / 1	No				WORK ORDER NON-	COI	<b>NFORI</b>	MANCE / UP	DATE		_	
											QA Closed:	Date:	
   Work Order	÷.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK Older	·· —					Rework	7		Skid-tube	Crosstube	]	Water Jet	Engineering
Part No	0.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	o					Work Order Update				Composite	]	Supplier	
							Γ.	'A'	Γ	A:	Cian 0	T	
Root		.   .	۲.	٥. ا		ption of work order update	1	Initial	ł	tion	Sign &	Verification	OC Inchestor
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Operator									ļ				
Material													
Setup													
Other		ļ											
Process		1							•				
Supplier							ļ						
Training		İ											
Unapproved													
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Landin	g Gear					General		_			_		
	Bend	ding				Bend		Grain			Ovalized		Pressure/Forced
	Cent	re Not	Concer	ntric to (	o/s	BOM/Route		Hardwa	are		Over/Under	tolerance	Temperature/Cure
Cracks						Broken/Damaged Inspection Incomplete					Part Incorre	ct	Weld

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

R1.44 15.50 2.00 R3.38 2 PL 20.18 REF

3 D4020-11 END MESH, BASKET

DELEASE 1 2010 -03- 12

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 Ibs
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

		* *							
DESIGN	AJS	DART AEROSPACE LTD							
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA							
CHECKED	9	DRAWING NO. REV. A							
MFG. APPR.	B	D4020 SHEET 3 OF 4							
APPROVED	100	TITLE SCALE							
DE APPR.	#	350 BASKET MESH (BASE) INTS							
DATE 10.0	03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOQUENT IS PRIVATE AND CONFIDENTIAL AND SUPPLED ON THE EXPRESS CONFIDENTIAL TILES AND THE LIGHT FOR ANY ABSOLUTE OCCUPANT OF CHARACTERS FOR CH							

											DQA:	Date:	:
NCR:	es /	/ No				WORK ORDER NON-CONFORMANCE / UPDATE							
				_							QA Closed:	Date	:
Work Order: DISPOSITION AGAINST							AGAINST DE	PARTMENT					
Part No.  NCR No.						Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Finish Se-as-is Thermoforming Finish			Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update	ĺ	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material											]		
Setup						,							
Other			,										
Process													
Supplier													·
Training													
Unapproved													
						F/	AUL	T CATE	GORY				
Landi	ng Ge	ear			_	General					,	_	7
	Bending Bend						<u> </u>	Grain		<u> </u>	Ovalized		Pressure/Forced
	Centre Not Concentric to O/S BOM/Route							Hardwa	re	<u></u>	Over/Unde	tolerance	Temperature/Cure
	$\Box$ c	cracks				Broken/Damaged		Inspecti	ion Incomplete	<u></u>	Part Incorre	ct	Weld
		Crushed/0	Crimped			Burrs		Instructions Incomplete/Unclear			Part Lost/M	<u>_</u>	Wrong Stock Pulled
		Cuffs				Contamination		Maintenance			Part Moved		•
		leat Trea	t			Countersink		Mislabe	eled		Positioned '	Wrong	_
	Inspection Strip in Tube					Microse	4		Power Loss	/Surge	Other		

Offset

Out of Calibration

Out of Sequence
Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio